

Date:  
User:Thursday, 3/8/2007 1:21:05 PM  
Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 31136		
Estimate Number	: 12786		
P.O. Number	: N/A	Part Number	: D35645
This Issue	: 3/8/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3564 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 3/15/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	6 Um: Each
Comment	: Est Rev:A New Issue 07-03-08 ec		

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 1.1099 sf(s)/Unit Total: 6.6591 sf(s)  
 M304S16GA Stainless steel sheet 0.063" thick  
 Batch: M7106

SAD 07/03/11

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3564  
 Dwg Rev: A  
 Prog Rev: A

2-Deburr if necessary

SAD 07/03/11

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/03/11

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

M07/03/12 (6)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary  
 Form on Brake as per Dwg D3564 using Jigs DT and DT  
 Form Joggle as per Dwg D3564 on brake using Jig DT

SB 07/03/13 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RP Date: 07/03/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:21:06 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31136

Part Number: D35645

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

*M 07/03/13 (6)*

7.0

POWDER COATING

POWDER COATING



*m10/601*



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*SL/M.H 07/03/14 (6)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*07/13/15 (6) Cc*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*07/15/15 (6) Cc*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



*(6)*

Comment: FINAL INSPECTION/W/O RELEASE

*07/15/15*

Job Completion



*U 07/03/15*

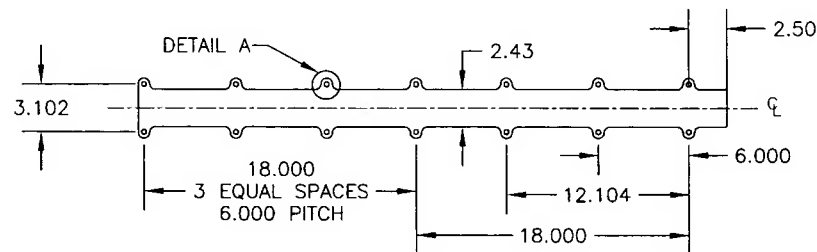
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

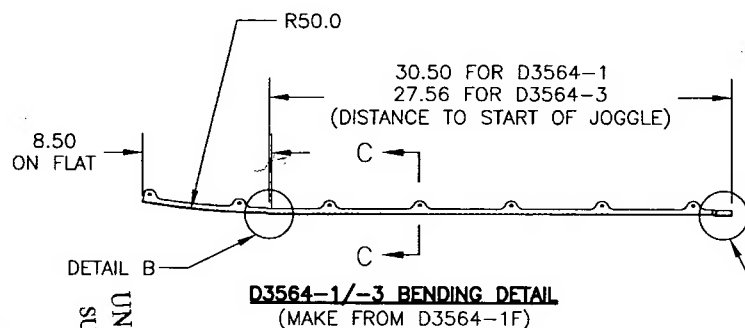
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

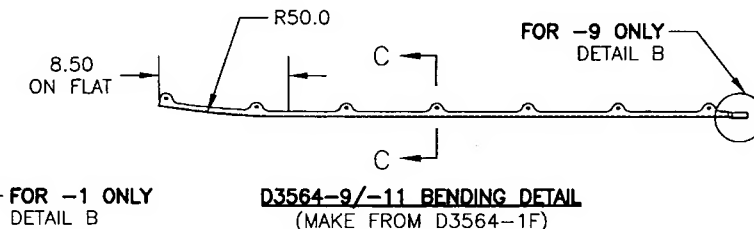


**D3564-1F FLAT PATTERN**

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RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO.



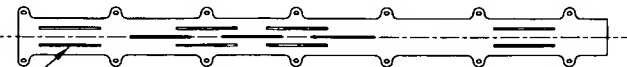
**D3564-1/-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-9/-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

FOR -1 ONLY  
DETAIL B

2059B HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308



**D3564-1/-3/-9/-11 WELDING DETAIL**

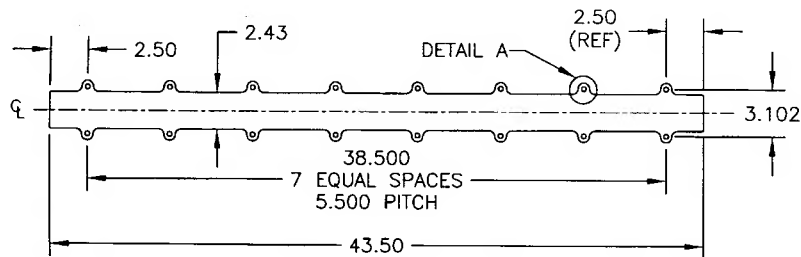
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NO. 31136

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07.07.28

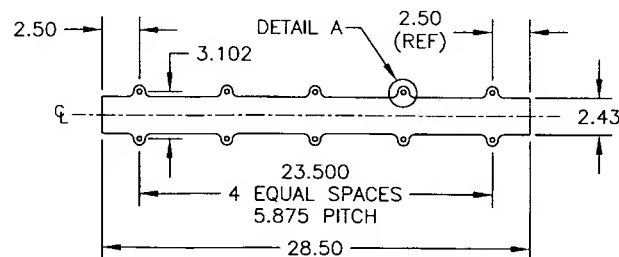
**D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

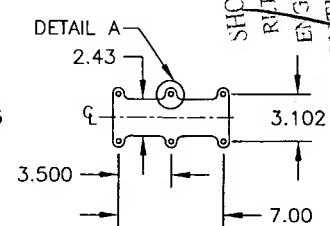
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				D3564	SHEET 1 OF 2
DATE		TITLE		SCALE	
06.12.18		WEARSHOE		1:8	



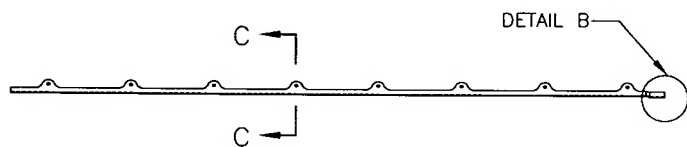
**D3564-5F FLAT PATTERN**



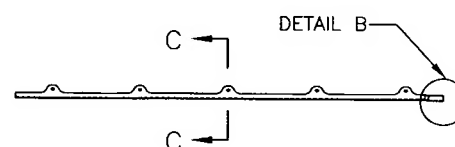
**D3564-7F FLAT PATTERN**



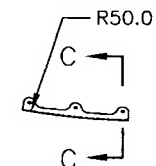
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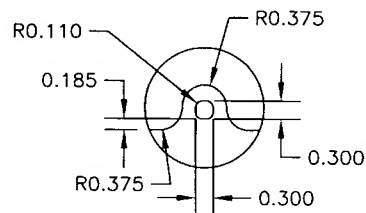
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



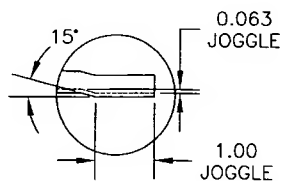
**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



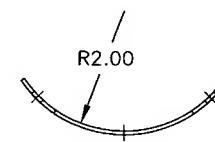
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



**DETAIL A**  
SCALE 1:2



**DETAIL B**  
SCALE 1:2



**SECTION C-C**  
SCALE 1:2

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07 02 78

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DATE 06.12.18		TITLE WEARSHOE	SCALE 1:8

